

Work Order ID 58515



Page 1

May 10, 2010 7:52:47 AM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 5/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHC002

5/10/10

0001
Eulerplever

HA for BG 10/05/19

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod: M112860

3-Grind End Plate flush

10.05.12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 0 3E 10/05/12

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Si 10/05/12



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-05-12

10 0

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

HS

10/05/12

10

φ

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R: Aluminum Rod: M112360

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10/05/14

10 φ

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 0 BE 10/05/17

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/05/17



210

Chemical Conversion Coat per QSI005 4.1

0.00



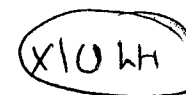
HandFinish

Memo

0.00

Hand Finishing

88 10/05/17



9

Work Order ID 58515

May 10, 2010 7:52:59 AM



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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM
OVEN TEMPERATURE: 320 °C
FINISH TIME: 10:30AM

=> 91 10/05/18

X106H 9

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-5-18.

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Rec'd 10/19

Work Order ID 58515

May 10, 2010 7:52:59 AM



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-5-19 SL (10)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 w/15/10

(X10 LA)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: REC B

Per 14/10 (10)

Work Order ID 58515

May 10, 2010 7:53:05 AM



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Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/21 *[Signature]*

U 10:05:20

Picklist Print

May 10, 2010 7:52:42 AM

Page 1

Work Order ID: 58515

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/10/10

Required Date: 5/28/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

AN3-35A Purchased No 250 Each 70.0000 2



Bolt

Location Loc Qty Loc Code

ST353 70

114382 50

114523 20

AN4-13A Purchased No 250 Each 332.0000 8



Bolt

Location Loc Qty Loc Code

ST351 300

114523 300

ST357 32

114181 6

114495 19

4828 7

AN5-36A Purchased No 250 Each 131.0000 2



Bolt

Location Loc Qty Loc Code

ST341 131

114292 131

AN960JD10 Purchased No 250 Each 0.0000 4



Washer

AN960JD416 Purchased No 250 Each 0.0000 16



Washer

10-5-19 M112314 SP

10-5-19 SP

80

10-5-19 SP

20 M114292 10-5-19 SP

SP M114576 10-5-19

(106)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 58515

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 5/10/10

Required Date: 5/28/10

Comments: IPP Rev:A: 104.03.22: New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter. ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

AN960JD516 ~~113706~~ Purchased No 250 Each 0.0000



Washer

D2230-3 Manufactured No 250 Each 169.0000



Lug

Location Loc Qty Loc Code

ST176 4

51566 4

ST476 165

56855 65

57827 100

D2618 Manufactured No 250 Each 117.0000



Bushing

Location Loc Qty Loc Code

ST020 117

56892 17

57829 100

D2856-400 Manufactured No 250 f 296.8768



Abraison Strip

Location Loc Qty Loc Code

ST403 296.8768

50593 80.8768

56626 216

M 113706 10-5-19 sl

10-5-19 sl

10-5-19 sl

Y

11

25

10-5-19 sl

10-5-19 sl

104

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Shop Packet Print

Page 2

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Start Date: 5/10/10

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Comments: IPP Rev:A: 04.03.22: New issue: IKJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

D3065-041 Manufactured No 180 Each 34.0000 1



Step Leg Assembly Hi



Pl 10.05.13

Location Loc Qty Loc Code

WA 34
56827 18
58160 16

10

D3066-1 Manufactured No 180 Each 97.0000 2



Spacer



Pl 10.05.13

Location Loc Qty Loc Code

WA 97
57920 97

20

D3067-1 Manufactured No 110 Each 127.0000 1



End Plate



Location Loc Qty Loc Code

WA 127
57926 127

10

Pl 10.05.11

D3067-1 Manufactured No 180 Each 127.0000 1



End Plate



Location Loc Qty Loc Code

WA 127
57926 127

10

Pl 10.05.13

May 10, 2010 7:52:43 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 4

Work Order ID: 58515

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Start Date: 5/10/10

Required Date: 5/28/10

Comments: IPP Rev:A 10.03.22 New issue - KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No 110 Each 21.0000 2
Plate

Location Loc Qty Loc Code
WA 21

56826 21

D3235-1 Manufactured No 250 Each 47.0000 2
Mounting Lug

Location Loc Qty Loc Code
ST471 47

55315 7

57921 40

D3272-1 Manufactured No 110 Each 0.0000 1
Step

D3278-041 Manufactured No 250 Each 52.0000 1
Support Assembly

Location Loc Qty Loc Code
ST471 52

55318 15

57952 37

10-05-11

20
10-5-19 SP

20
10-05-11 358516

10-5-19 SP

3
X

100

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Page 4

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 IPP Rev:B 07-06-09 Added D3272-1 JLM;
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
 by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4 Purchased No 180 Each 543.0000 16



Rivets

PL 10.05.13

Location Loc Qty Loc Code

ST321 543

113368 62

114181 481

MS21042L3 *142* Purchased No 250 Each 1,673.000 2



Nut

160

10-5-19 SP

Location Loc Qty Loc Code

ST300 1673

113537 20

113644 653

114523 1000

MS21042L4 *18* Purchased No 250 Each 2,288.000 8



Nut

20

10-5-19

SP

Location Loc Qty Loc Code

ST139 2

111827 2

ST300 2098

113422 96

114523 1994

9063 8

ST463 188

114416 188

80

SP

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by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

82

Purchased

No

250

Each

625.0000

2



10-5-19 SF

540 Nut

Location

Loc Qty

Loc Code

ST300

625

113523

26

113537

3

114108

96

114437

100

114449

400

20

100

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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Dart Aerospace Ltd

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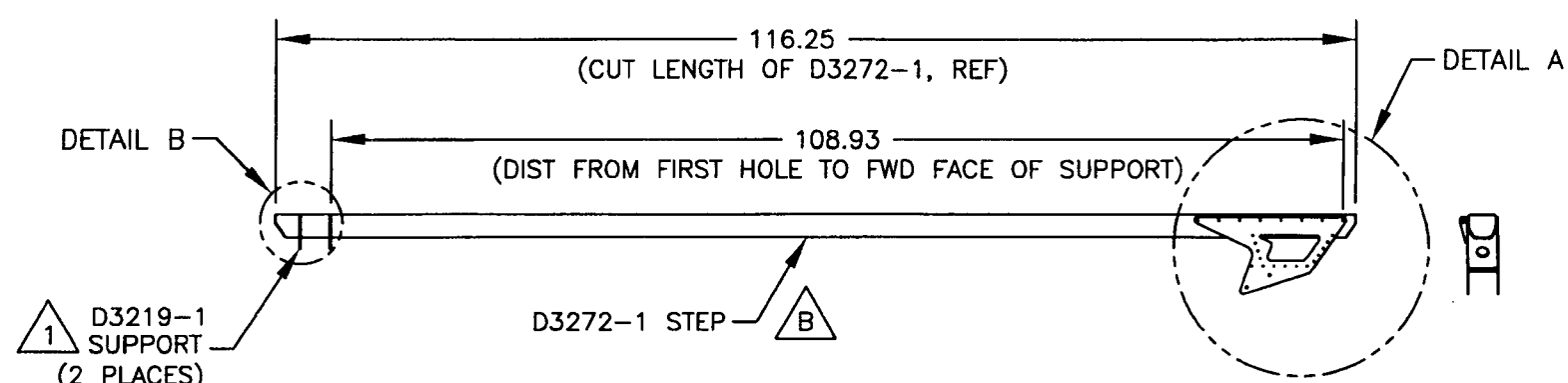
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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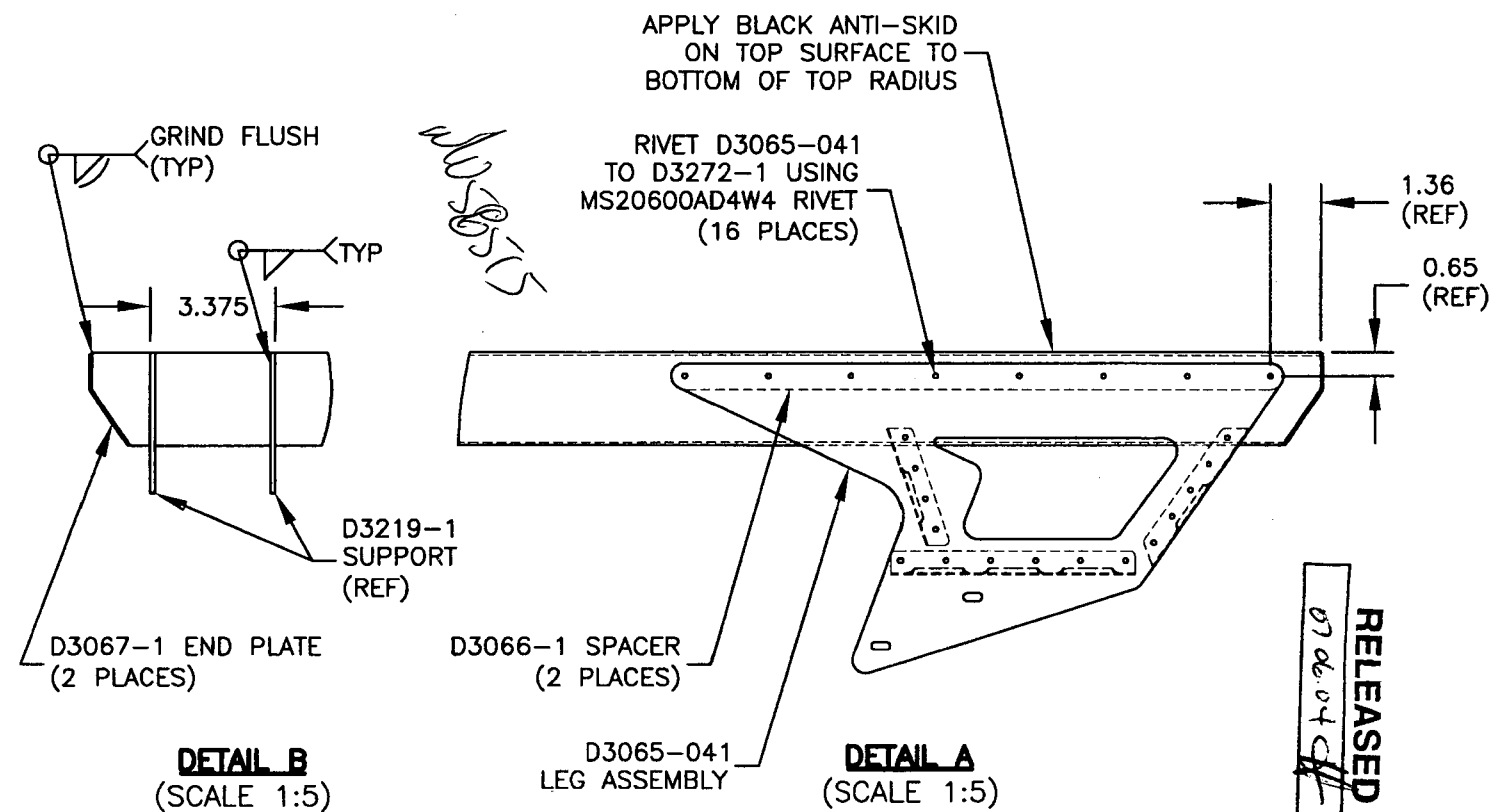
NOTE: Date & initial all entries



DESIGN	40	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

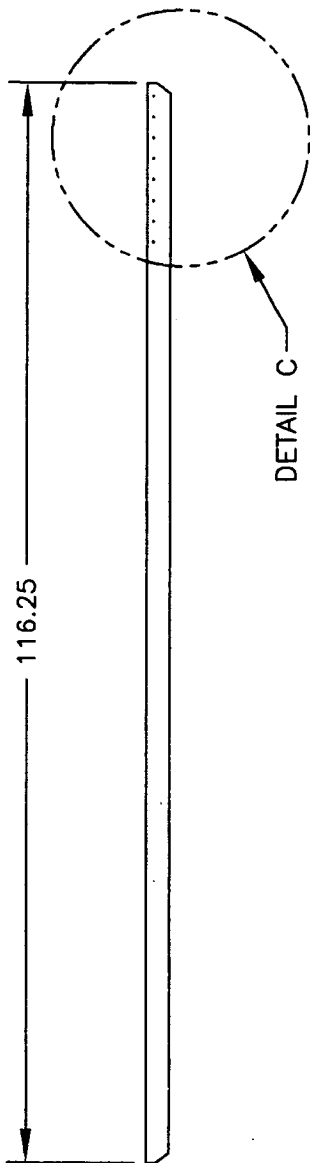
NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

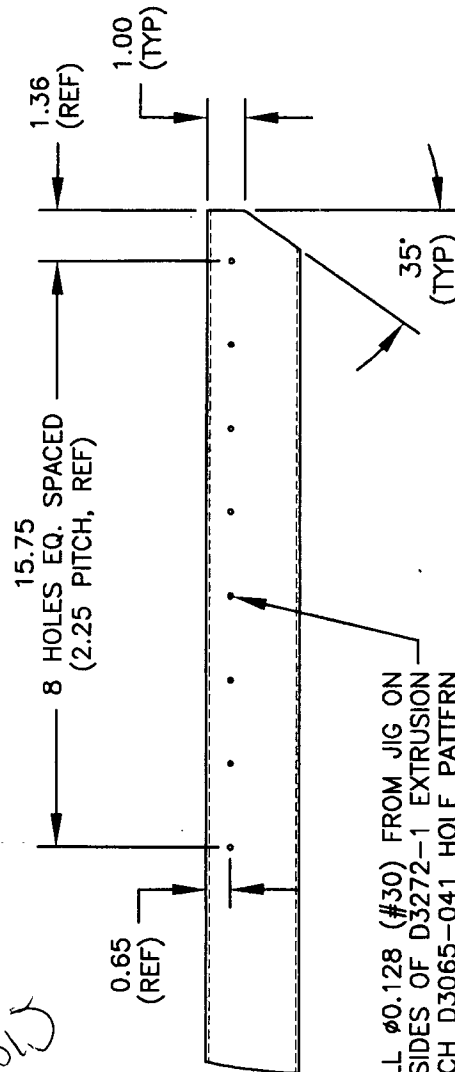
07.06.04 *[Signature]*



DETAIL C

B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)

58515



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty	Qty	Qty	Qty	Qty	Qty	Qty	Qty	Part Number	Description
-211	-212	-213	-214	-215	-216	-311	-312		
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
								D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
								D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
				2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4			4	4			D2732-030	CUSHION
2	2			1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2			2	2	2	2	AN3-35A	BOLT
10	10			2	2			AN4-11A	BOLT
				4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4		5	5	4	4	4	AN960JD10	WASHER
20	20		2	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2			2	2	2	2	MS21042L3	NUT
10	10			5	5	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option to the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-31-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries